

order 6184

31 Aug



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C10-21-2
Job Sheet 178872



12-5
7-14

45

Part No: C10-21-2
Part Name: Spring Cover

Job Qty: 20 ea



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/8/18

Job Tracking No:

Due Date: 6/29/18 817-18

DAS
21
9-89

Created By: Marie Lajeunesse

Description:

Note: DWG C10-21-2 Rev. 2 IPP Rev. A 18.04.16 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		6/29/18	0.00	0.00	Start Up Machining-2		
110	CNC Lathe	20 pcs		6/29/18	0.00	5.00	MORI NLX		
120	QC	20 pcs		6/29/18	0.00	0.00	QC2 Machining-4		
130	QC	20 pcs		6/29/18	0.00	0.00	QC8 Machining-4		
150	Outsource	20 pcs		6/29/18	0.00	0.00	Outsource4		
160	Packaging	20 pcs		6/29/18	0.00	0.00	Packaging2		
170	QC	20 pcs		6/29/18	0.00	0.00	QC6		
180	Packaging	20 pcs		6/29/18	0.00	0.00	Packaging3-1		
190	QC21-SA	20 Ea		6/29/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FOLIO REV: _____ DWG REV: _____ 2-Debur

Descriptions: 150 - Issue P/O to GROUPE ALTECH: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2
CLASS 2, Water sealant -Certificate of Conformity is required

120 - ENGRAVE BATCH NUMBER USING MARKTROWIC ENGRAVER AS PER DWG

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6R3.000	6061-T6 Round Bar 3.000"	1.8750 ft (.09375 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6R3.000	2	18	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 6/8/18 1:04 PM Dart.lajeunesse.marie

Container No: S108588



Part: C10-21-2

Job No: 178872

Serial No/Batch: S108588

Revision: 2

Inspector:

Exp Date:

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order:	178872
Description: Spring cover		Part Number:	C10-21-2
Inspection Dwg: C10-21-2	Rev: 2	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.833	$\pm .005$	.833	✓		Vern L P09	
.770	$\pm .005$	.770			↓	
1.05	$\pm .01$	1.051			↓	
45°	$\pm .5°$	45°			Protractor	
Ø .201	$\pm .005$	.201			gauge pin	
Ø .38	$\pm .01$	.380			↓	
.63	$\pm .01$	.632			Vern L P09	
Ø 2.402	$\pm .005$	2.403			↓	
Ø 2.875	$\pm .005$	2.875			↓	
Ø 2.027	$\pm .005$	2.027			↓	
Ø 1.908	$\pm .005$	1.912			↓	
Ø 2.20	$\pm .01$	2.204			↓	
.36	$\pm .01$	.364			↓	
.13	$\pm .01$	.132			↓	
R.06	$\pm .01$	.062			Rad gauge	
R.03	$\pm .01$	.031			↓	

Measured by: 	Checked by: 	QC Inspector:
Date: 18-09-06	Date: 18/09/12	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

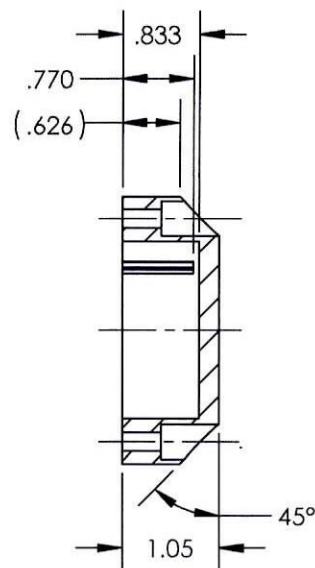
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		AS DRAWN BY CANAM.	5/3/2013	CFS	
2	14-0114	CH'D TITLE BLOCK WAS RED BARN IS DART. ADDED MACHINE ENGRAVE NOTE. CH'D TOLERANCE ON NON-CRITICAL DIMENSIONS.	8/8/2014	DPD	RW



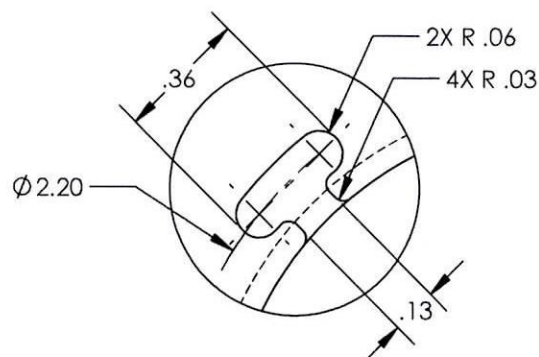
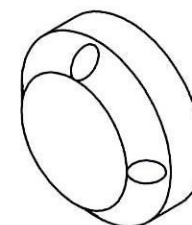
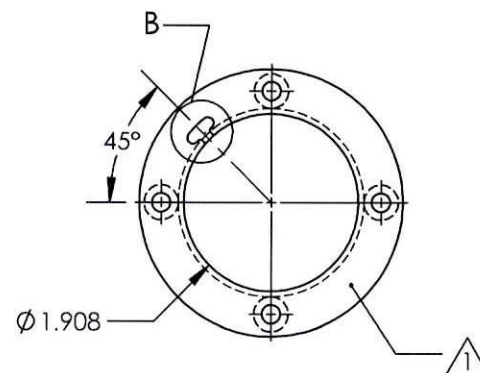
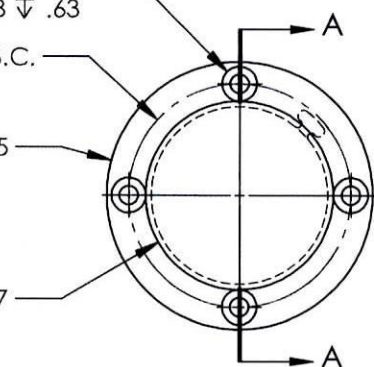
SECTION A-A

4X ϕ .201 THRU ALL
 ϕ .38 ∇ .63

ϕ 2.402 B.C.

ϕ 2.875

ϕ 2.027



DETAIL B
 SCALE 2 : 1

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 178872
 MJS 1806-08

NOTE:

1 MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE SPRING COVER	
DWG NO. C10-21-2	REV 2
MAT'L 6061	DRAWN BY: CANAM
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.005 .XX $\pm$.01 .X $\pm$.1	APPROVED <i>D West</i> HEAT TREAT FINISH BLACK ANODIZE
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SPEC MIL-A-8625F, TYPE II, CLASS II USED ON MODEL
SCALE 1:2	DATE 4/26/2002 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C10-21-2	1	SPRING COVER	6061	ϕ 3 X 1-1/8

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040995**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO040995
PO Date: 9/12/18
Due Date: 9/21/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Phone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1		C10-21-2	Spring Cover -Issue P/O to GROUPE ALTECH: -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	-	9/21/18	20 pcs	0 pcs	20 pcs	\$6.00/pcs	\$120.00

DAS
38
9-89

Line Item Note ** asap please **

Grand Total: \$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 9/13/18 12:44 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

012594 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
19-Sep-2018		SVETLANA DORZHIYEVA		PO040995				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Quantités / Quantities				
	Job # / Ref #			Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	C10-21-2 Rev.	C10-21-2 01 -ANO-BLACK [ANODIZE BLACK] PER IAW MIL-A-8625F TYPE2 CLASS 2 WATER SEALANT	ANODIZE CH	20	20	0	0	0

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9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.